

Date: Thursday, 02/10/2008 8:24:11 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: VERTICAL TUNNEL W/O DUCTING R/H
Job Number	: 42387		
Estimate Number	: 13607		
P.O. Number	:	Part Number	: D38284
This Issue	: 02/10/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D38284 PROTOTYPE
First Issue	: //	Project Number	:
Previous Run	:	Drawing Revision	: PROTOTYPE
	Type : R&D THERMOFORMING	Material	: KYDEX 6185 (TBD)
Written By	:	Due Date	: 17/10/2008
Checked & Approved By	: <u>JUL 08.10.02</u>	Qty:	1 Um: Each
Comment	: Est. Rev. A New Issue 08.09.25 DL		

Additional Product

PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
Comment: HAND FINISHING THERMOFORMING		
1) Machine set up DL 08.10.03		
2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
		(X)
Comment: HAND FINISHING THERMOFORMING		
1) Cut sheet to required blank size DL 08.10.03		
3.0	THERMOFORMING	THERMOFORMING MACHINE
Comment: THERMOFORMING MACHINE		
Thermoform as per Dwg. D3828-4 and folio (FTA 9233Prototype) using tool DT 9233 (X)		
Dwg. Rev. <u>PROTOTYPE</u>		
Folio Rev. <u>A</u> DL 08.10.03		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		(X)
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
Visually inspect for proper formation of each part DL 08.10.03		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description:
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5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

PROTOTYPE

KEEP IN ENG'G LAB # 09.02.20

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



00251A tooling used per drawing

09.02.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries